

Work Order ID 70125

Friday, May 27, 2011 10:56:41 AM



Page 1

Item ID: D3214-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Placard

Start Date: 6/2/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 6/6/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-05-27

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3214

Rev B

100

0.00



SHEAR

Shear

Memo

0.00

Shear

Cut blanks: 3.70" x 2.70" ☐ Drill hole and fillet corner as per Dwg
D3214 ☐ Deburr ☐ Identify as D3214-1

11/06/03

6

110

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

8/10/03

x6

120

0.00



Chemical Conversion Coat per QSI005 4.1

HandFinish

Memo

0.00

Hand Finishing

11/06/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
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Start Date: 6/2/2011

Start Qty: 6.00



Cust Item ID:

Required Date: 6/6/2011

Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC2- Inspect parts off machine FAI/FAIB

0.00

cmh 11/06/09

QC

Memo

0.00

6 *8*

Quality Control

180

Identify as per dwg & Stock Location: *202*

0.00



Packaging

Memo

0.00

11/6/9 *60 SP*

Packaging

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

11/6/09 *MF*

Quality Control

MF
11-06-09

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Picklist Print

Friday, May 27, 2011 10:56:47 AM

Page 1

Work Order ID: 70125

Parent Item: D3214-1

Parent Item Name: Placard




Start Date: 6/2/2011

Required Date: 6/6/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP A 04.04.15 New issue KJ/RF
IPP Rev:B Now 6061-T6 06-06-23 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080 		Purchased	No			110	sf	331.0000	0.0743	0.469263			

6061-T6 .080 Sheet

Location

Loc Qty

Loc Code

MAT021

331

116268

33.5

117285

297.5

15  11/06/03

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DART

DESIGN T#	DRAWN BY C.B.	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D3214	REV. B SHEET 1 OF 1
DATE 06.05.29		TITLE PLACARD	SCALE 1:1
A	04.01.27	NEW ISSUE	
B	06.05.29	ADD 6061-T6 MATERIAL	

RELEASED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 70123
PH-05-27

D3214-1**NOTES**

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027)
0.080" THICK (REF DART SPEC M6061T6S.080)
OR
5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK
(REF DART SPEC M5052H32S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (REF. 4.3.5.7) PER DART QSI 005 4.3
- 3) ENGRAVE LETTERS (0.50" HEIGHT) AS SHOWN AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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